

Work Order ID 43731B

Friday, June 26, 2009 8:39:18 AM



Page 1

Item ID:	D3324-041	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Basket Base Assembly					
Start Date:	7/15/2009	Start Qty:	1.00	Cust Item ID:		
Required Date:	8/3/2009	Req'd Qty:	1.00	Customer:		
Reference:						

Approvals:	Process Plan:		Date:	Tooling:		Date:		Run	Start	
	QC:		Date:	SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3324	Rev B

100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Cut tubes as per Dwg D3324								

Batch 7109385 3D3324-1Bottom Tube 7109385 4D3324-3Full Length Tube
 2D3324-5Top End Tube 7109385 2D3324-7Bottom
 EndTube 7109385 10D3324-9Vertical Tube

SAN 09-07-02

7109385 SAN

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									

120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

⇒ 809/02/15 (1) 1 φ

09-07-14 PTO

09-07-15

Work Order ID 43731B

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Item ID:	D3324-041	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Basket Base Assembly					
Start Date:	7/15/2009	Start Qty:	1.00		Cust Item ID:	
Required Date:	8/3/2009	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Pressure WASH	0.00 Umo 09/07/15							
	Memo	0.00							
	1ST COAT: <input checked="" type="checkbox"/> START TIME: 10:30a <input type="checkbox"/> FINISH TIME: 11:20								
	2nd coat if necessary <input type="checkbox"/> ***** <input type="checkbox"/> 2ND COAT: <input type="checkbox"/> START TIME: 11:20 <input type="checkbox"/> OVEN TEMPERATURE: 400°F								
140 QC Quality Control	QC3- Inspect Part Finish	0.00							
	Memo	0.00							
150 Packaging Packaging	Identify as per dwg & Stock Location: G-A	0.00							
	Memo	0.00							

(P10)

Ep 09/07/16 @

Ep 09/07/16 @

Picklist Print

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Friday, June 26, 2009 8:39:17 AM

Work Order ID: 43731B



Parent Item: D3324-041RevB



Parent Item Name: Basket Base Assembly

Start Date: 7/15/2009

Required Date: 8/3/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ D3328-3RevB 		Manufactured	No			100 ✓	Each	0.0000	2.0000			
Basket Hinge									B33872 ✓			
✓ D3348-1RevB 		Manufactured	No			100 ✓	Each	0.0000	4.0000			
Clevis									B41830 ✓			
✓ D3349-3RevA 		Manufactured	No			100 ✓	Each	0.0000	2.0000			
Spacer Bushing									B41831 ✓			
✓ D3367-1RevA 		Manufactured	No			100 ✓	Each	0.0000	2.0000			
Mounting Bracket									B43228 ✓			
✓ M4130NTS0.500W.035 		Purchased	No			100 ✓	f	0.0000	49.0526			
4130 Square tube .500 x .500 x .035w									M109385 ✓			
✓ M569EX0.50-18F 		Purchased	No			100 ✓	sf	0.0000	28.0000			
569 Expanded Metal									M109289 ✓			

SAM 09-07-18

09-07-15

035 121-041

Date: Wednesday, 26/11/2008 9:14:52 AM
User: Julie Dawson









Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BASKET BASE ASSEMBLY
Job Number : 43731B	
Estimate Number : 10852	
P.O. Number :	Part Number : D3324041
This Issue : 26/11/2008 S.O. No. :	Drawing Number : D3324 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : B
Previous Run : 41774B	Material :
Written By :	Due Date : 03/12/2008 Qty: 1 Um: Each
Checked & Approved By : <u>JUD 08.11.26</u>	
Comment : Est Rev:A 05.02.09 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D33283	Basket Hinge
 		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch 2 D3328-3 Hinge Plate <u>B33872</u>		
2.0	D33481	Clevis
 		
Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part Number Description Batch 4 D3348-1 Clevis <u>B41830</u>		
3.0	D33493	Spacer Bushing
 		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch 2 D3349-3 Spacer Bushing <u>B418031</u>		
4.0	D33671	Mounting Bracket
 		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch 2 D3367-1 Mounting Bracket <u>B43228</u>		

W/O: 43731B		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
09-07-17	100	Not all sequence procedures are showing in step 100. Show all work procedures step by step. Perm change	CE	09-08-10		090717	090717	
09-07-17	130	Add a step to pressure wash clean, prior to powder coating perm change.	IE	09-08-10		090717	090717	

Part No: D3324-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 26/11/2008 9:14:52 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY

Job Number: 43731B

Part Number: D3324041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

M4130NTS0500W035

4130 Square tube .500 x .500 x .035w



Comment: Qty.: 48.9300 f(s)/Unit Total : 48.9300 f(s)
Material: 4130 Cond. N Square tube per MIL-T-6736,
1/2" x 0.035" wall
M4130N-TS0.500W.035)

m109385

SAD 09-07-14

6.0

M569EX05018F

569 Expanded Metal



Comment: Qty.: 28.0000 sf(s)/Unit Total : 28.0000 sf(s)
Pick:
Qty Part Number Description Batch
28s M569EX0.50-18F 1/2"-18gauge(.040") carbon steel

m109289

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
1-Cut tubes as per Dwg D3324

Qty	Part Number	Description	Batch
3	D3324-1	Bottom Tube	<i>m109385</i>
4	D3324-3	Full Length Tube	<i>m109385</i>
②	D3324-5	Top End Tube	
2	D3324-7	Bottom End Tube	<i>m109285</i>
10	D3324-9	Vertical Tube	m109385 <i>m109385</i>

Identify parts appropriately

2-Remove all markings from material & check for foreign objects

SAD 09-07-14

3-Drill and Weld as per Dwg D3324 & QSI 004 using DT8781 A & B
A/R4130 Steel Rod *m100075*

4-Deburr as required

CP 09.07.14

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

AD 09.07.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 26/11/2008 9:14:52 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY

Job Number: 43731B

Part Number: D3324041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

***** 2nd coat if necessary*****

2ND COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____



11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

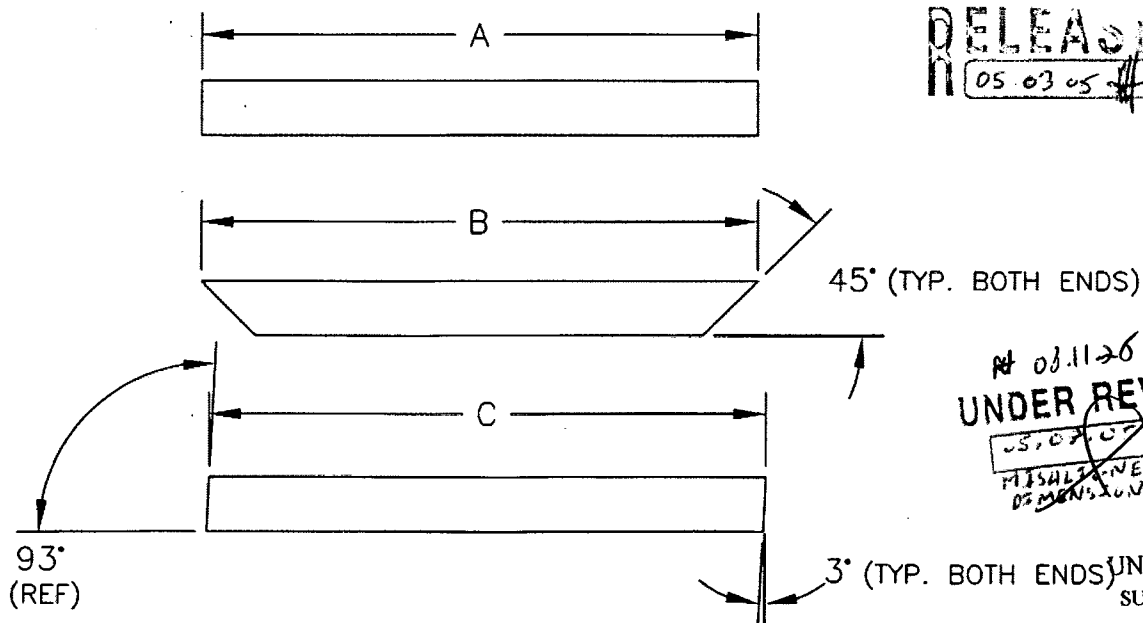
NOTE: Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3324	REV. B SHEET 1 OF 3
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	SCALE NTS
A	04.10.20	NEW ISSUE	
B	05.03.04	UPDATE MESH MATERIAL SPEC	

PARTS LIST FOR D3324-041 BASKET BASE ASSEMBLY

Part No.	Quantity (-041)	Length A	Length B	Length C	Description
D3324-1	3	14.00	N/A	N/A	BOTTOM TUBE
D3324-3	4	N/A	86.50	N/A	FULL LENGTH TUBE
D3324-5	2	N/A	16.00	N/A	TOP END TUBE
D3324-7	2	N/A	15.00	N/A	BOTTOM END TUBE
D3324-9	10	N/A	N/A	11.04	VERTICAL TUBE
D3328-3	2	N/A	N/A	N/A	HINGE PLATE
D3348-1	4	N/A	N/A	N/A	CLEVIS
D3349-3	2	N/A	N/A	N/A	SPACER BUSHING
D3367-1	2	N/A	N/A	N/A	MOUNTING BRACKET



RELEASED
05.03.05

03.11.26
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DIMENSION P.C.A.

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WORK ORDER
NO. 437313

D3324-1/-3/-5/-7/-9

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: 4130 COND. N SQ. TUBE PER MIL-T-6736, 1/2" SQ. x 0.035 WALL
(REF. DART SPEC M4130N-TS0.500W.035)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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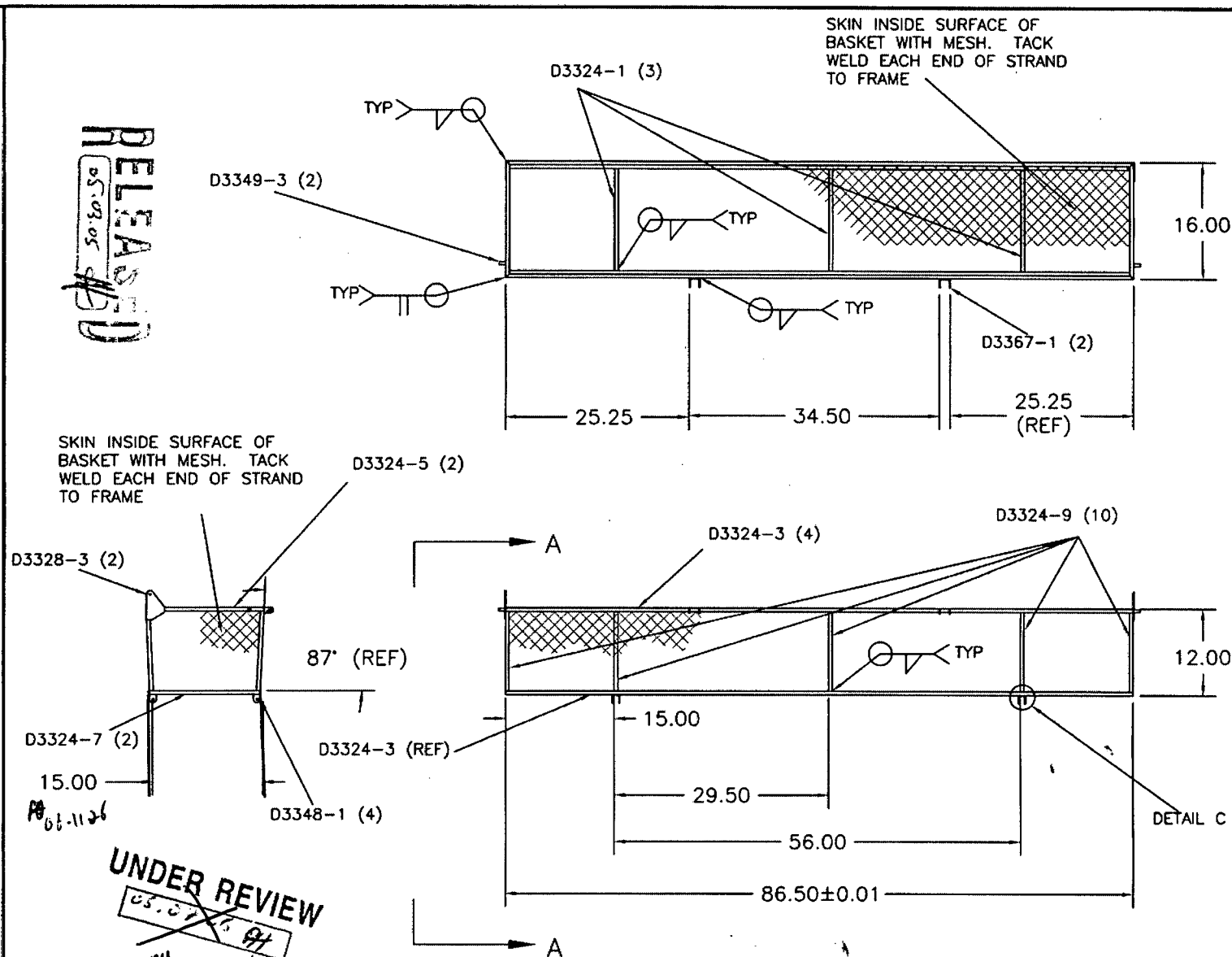
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05.03.04	05.03.04	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 2 OF 3
05.03.04	05.03.04	D3324	
DATE	TITLE	BASKET BASE ASSEMBLY	SCALE
			1:20

RELEASED
05.03.05

SKIN INSIDE SURFACE OF BASKET WITH MESH. TACK WELD EACH END OF STRAND TO FRAME



UNDER REVIEW
05.03.05

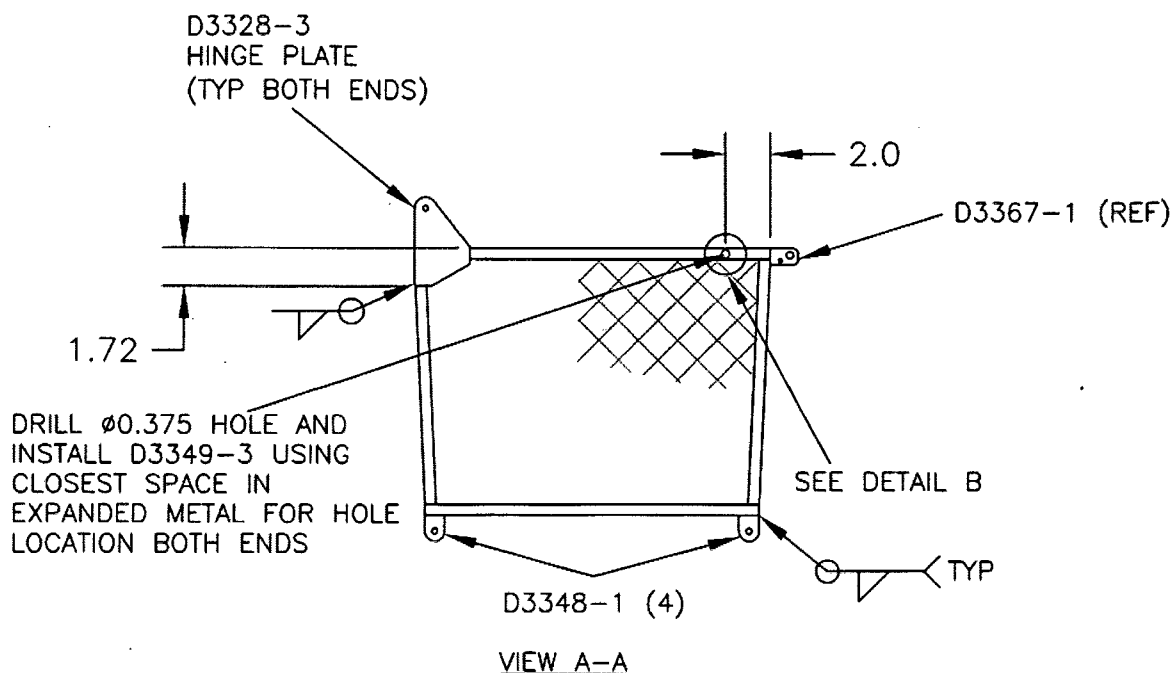
D3324-041 BASKET BASE ASSEMBLY

- 1) MESH MATERIAL: 1/2" - 18F GAUGE FLATTENED (0.040 THICK) EXPANDED CARBON STEEL (PER DART SPEC. M569EX0.50-18F)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 4.0 UNLESS OTHERWISE NOTED

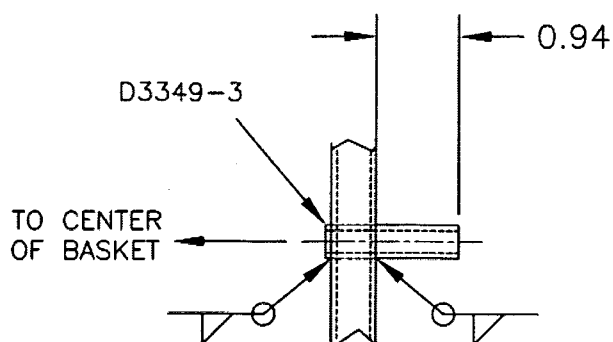
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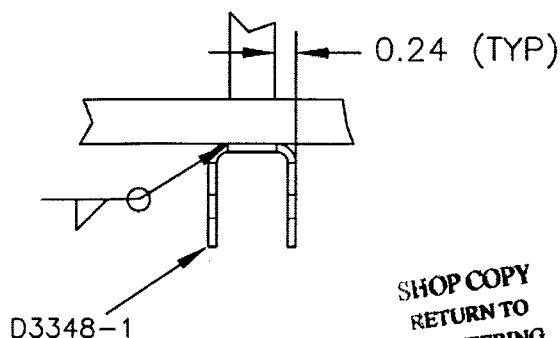
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3324	REV. B SHEET 3 OF 3
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	SCALE 1:8



RELEASED
05.03.05



DETAIL B
(SCALE 1:2)



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PH 06.11.06

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